

Work Order ID 70285

Thursday, June 02, 2011 1:17:15 PM

Page 1

Item ID: D3205-3

Accept

Revision ID:

Item Name: Back Plate

Setup Start

Stop

Start Date: 6/2/2011 Start Qty: 10.00

Required Date: 6/8/2011 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3205

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

out 11/09/03

10

8

Jeaspa Bandsaw

Cut blanks: 2.00" x 0.250" x 2.480" long Bar (+0.030/-0.000)

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

11.9.12

10

HAAS CNC vertical machine #1

Machine D3205-3 as per Folio FA343 and Dwg D3205; Identify as D3205-3; Deburr and Tumble

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

29 11.9.12

10

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 70285

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Page 2

Item ID: D3205-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Plate

Start Date: 6/2/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/8/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

11/09/12

10

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10X Ø m-11/09/12

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3200

9:10

9:40

10X Ø m-11/09/14

M 117338

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 70285

Thursday, June 02, 2011 1:17:15 PM



Page 3

Item ID: D3205-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Plate

Start Date: 6/2/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/8/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

counted
10

f. 10 u10812

170

Identify as per dwg & Stock Location: STGA

0.00



Packaging

Memo

0.00

Packaging

(Handwritten signature)

10x

80 11-09-14.

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/15

11-09-15

| W/O: | | WORK ORDER CHANGES | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, June 02, 2011 1:17:13 PM

Page 1

Work Order ID: 70285

Parent Item: D3205-3

Parent Item Name: Back Plate



Start Date: 6/2/2011

Required Date: 6/8/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP B 05.01.31 Revised Step 10 KJ/JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B0.250X02.00 0 | | Purchased | No | | | 100 | f | 48.5000 | 0.2175 | 2.289474 | | | |



6061-T6 Bar .250 X 2.00

Location

Loc Qty

Loc Code

MAT001

48.5

107436

48.5

2.29 mhl 11/09/03

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

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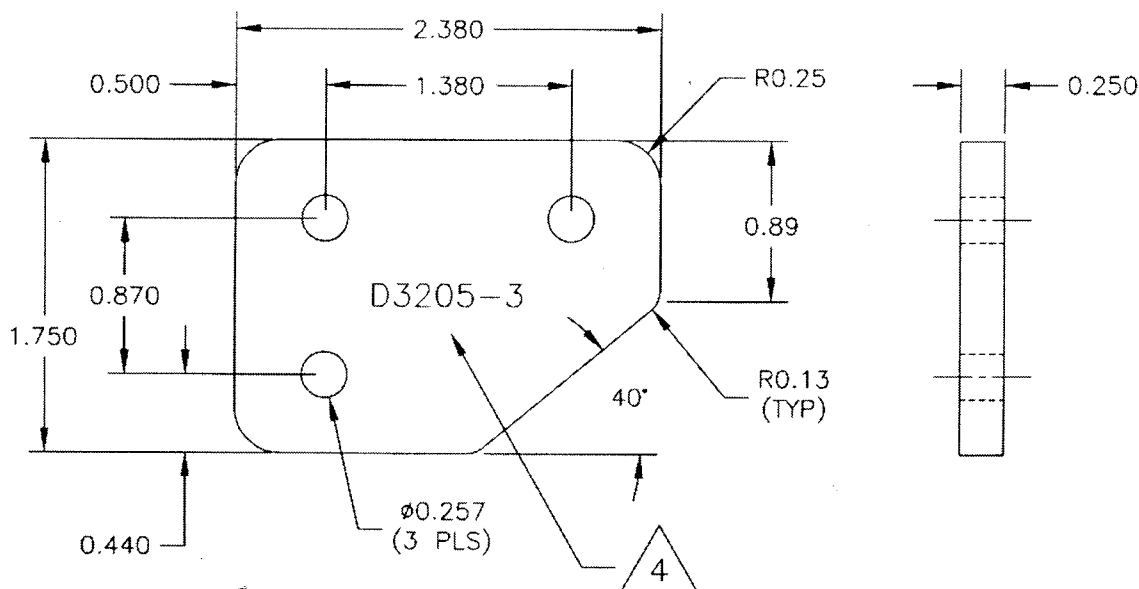
NOTE: Date & initial all entries



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| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | REV. A |
| DATE | | D3205 | SHEET 2 OF 2 |
| 04.01.27 | | TITLE | SCALE |
| | | BRACKET | 1:1 |

RELEASED

DEO ATTACHED



D3205-3 BACK PLATE

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

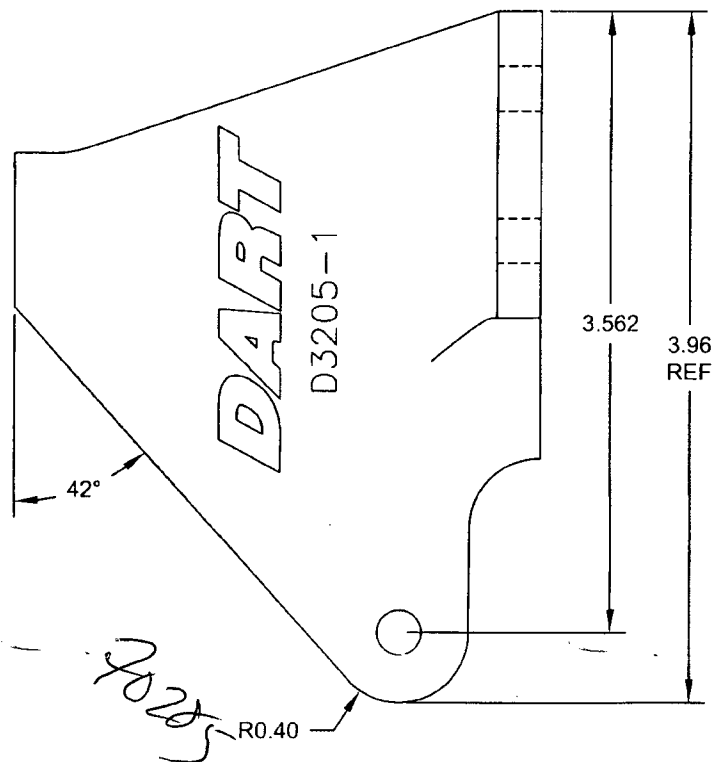
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NOTE: Date & initial all entries

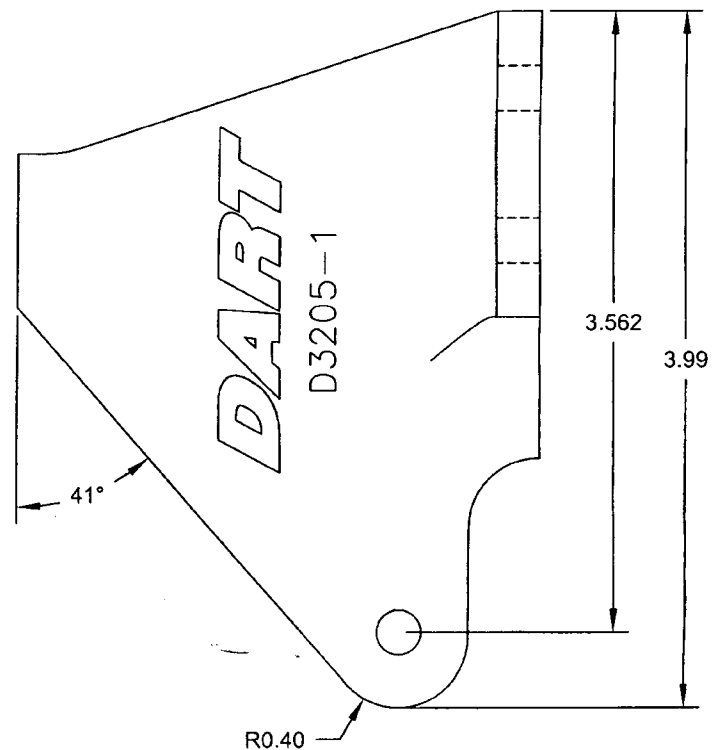
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|----------------------|-------------------------------|----------------------------------|---|--------------------------------|-------------------------|---------------------------|--------------|
| DRAWING NO. D3205 | TITLE BRACKET | REV. A | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D3205-A-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN AJS | CHECKED <i>[Signature]</i> | MFG. APPR. <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DE APPR. <i>[Signature]</i> | | | |
| DATE 08.12.01 | DATE 08.12.01 | DATE 08/12/01 | DATE 08/12/01 | DATE 08.12.01 | | | |

SHEET 1 MODIFY D3205-1 AS SHOWN:

IS:



WAS:



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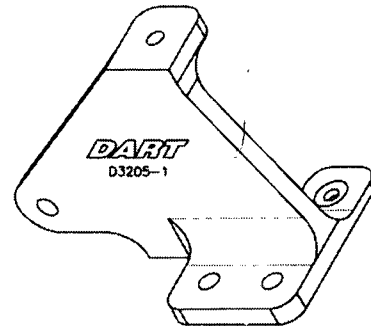
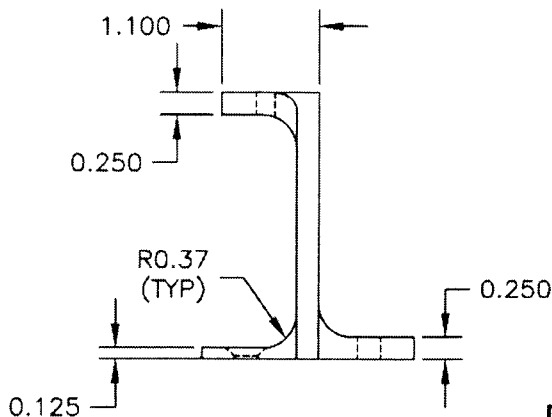
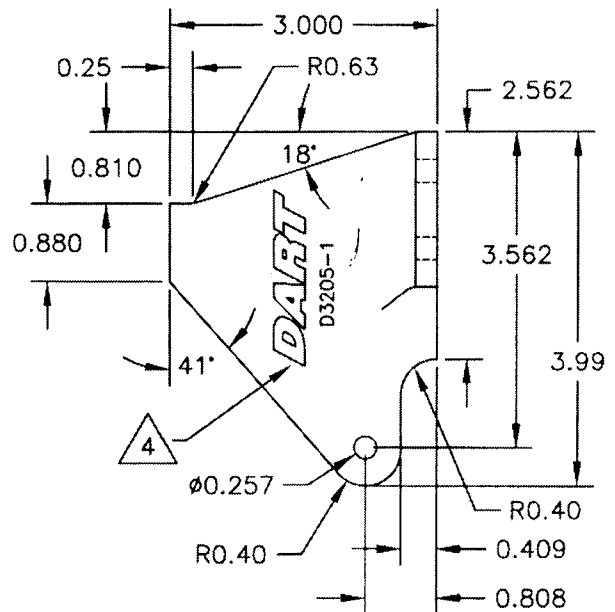
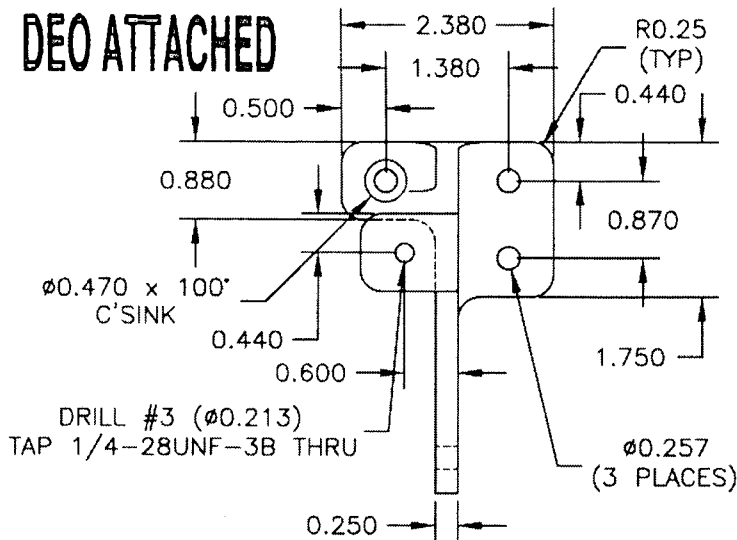
NOTE: Date & initial all entries



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|------------------|---------------|---|------------------------|
| DESIGN H | DRAWN BY H | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED H | APPROVED H | DRAWING NO. D3205 | REV. A SHEET 1 OF 2 |
| DATE 04.01.27 | | TITLE BRACKET | SCALE 1:2 |
| A | 04.01.27 | NEW ISSUE | |

RELEASED
04.01.27

DEO ATTACHED



D3205-1 PEDAL BRACKET

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 7075-T73 (QQ-A-200/11 OR QQ-A-250/12)
OR 2024-T3 (QQ-A-200/3 OR QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

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Dart Aerospace Ltd

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